

Work Order ID 63577

Thursday, November 04, 2010 1:08:13 PM



Page 1

Item ID: D3535-35

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 11/4/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

PL

Date: 10/11-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

B10-11-1

FLOW CNC Waterjet

304 .040

1-Cut as per Dwg D3535

 Dwg Rev: *B* Prog Rev: *B* 2-

Deburr if necessary

8

110



QC2- Inspect parts off machine FAI/FAIB

0.00

B10-11-1

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

S10-11-12

QC

Memo

0.00

Quality Control

CE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

SB 10/11/15

8

Brake NC

Memo

0.00

Brake NC

1-Deburr if necessary □ 2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. □ 3-Identify as D3535-35.

140



QC5- Inspect part completeness to step on W/O

0.00

8

QC

Memo

0.00

Quality Control

10/11/15

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

8

Powdercoat

Memo

0.00

Powder Coating

START TIME:

12:00

OVEN TEMPERATURE:

FINISH TIME:

12:30

6/10-11-17.

W/O:		WORK ORDER CHANGES					
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Page 3

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

=> M 10/11/17

8 0

QC

Quality Control

170



Identify as per dwg & Stock Location: FP-18 0.00

0.00

8 BK 10-11-17

Packaging

Packaging

Memo

0.00

180



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/11/17 JJ

MF
10-11-17

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

Thursday, November 04, 2010 1:08:17 PM

Work Order ID: 63577



Parent Item: D3535-35



Part Item Name: Wearshoe

Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	165.0000	0.8022	6.755368 			HB 10-1-11

304/316 .040 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	161	
115762	10.2	
115953	150.8	115953
MAT20	4	
113062	1.398	
115440	2.602	

8

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63579
Description: Gasket	Part Number:	D3536-35
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

AS
10.11.11

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-11-11	Date: 10/11/12		Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	SP

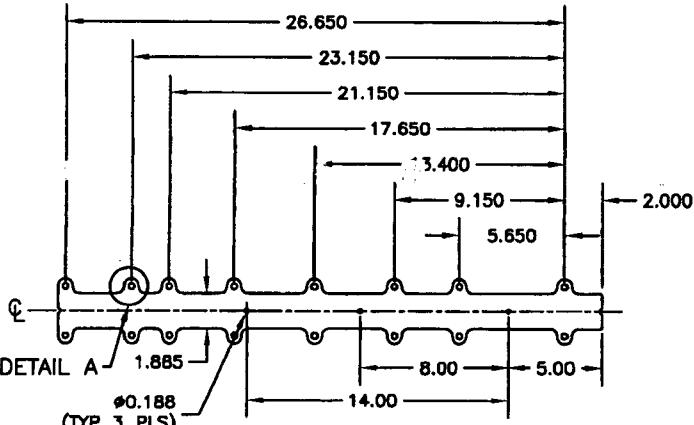
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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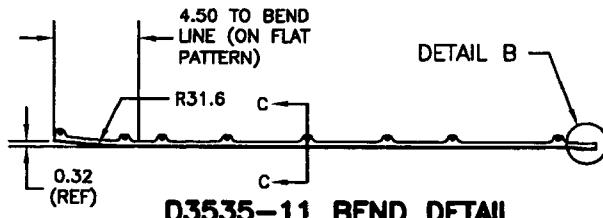
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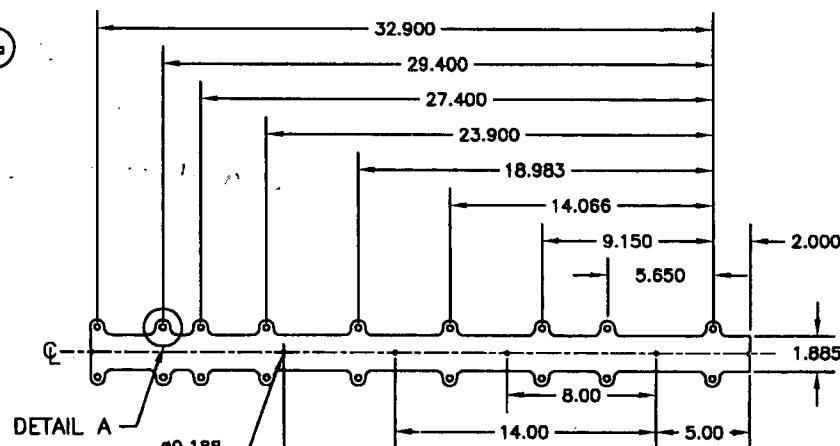
D3535-11F FLAT PATTERN



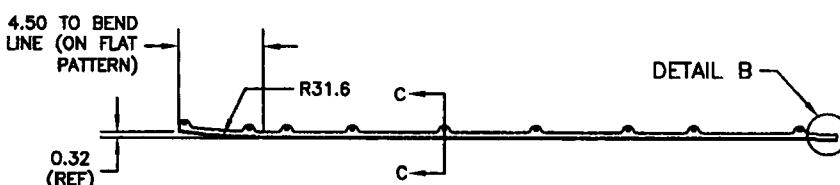
D3535-11 BEND DETAIL

SHOP COPY
RETURN
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 13377
B10-11-04

RELEASED
07.04.24
MM



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	MM	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
MM	MM	D3535
DATE		SCALE
07.04.17		1:10
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

REV. B
SHEET 1 OF 7
SCALE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

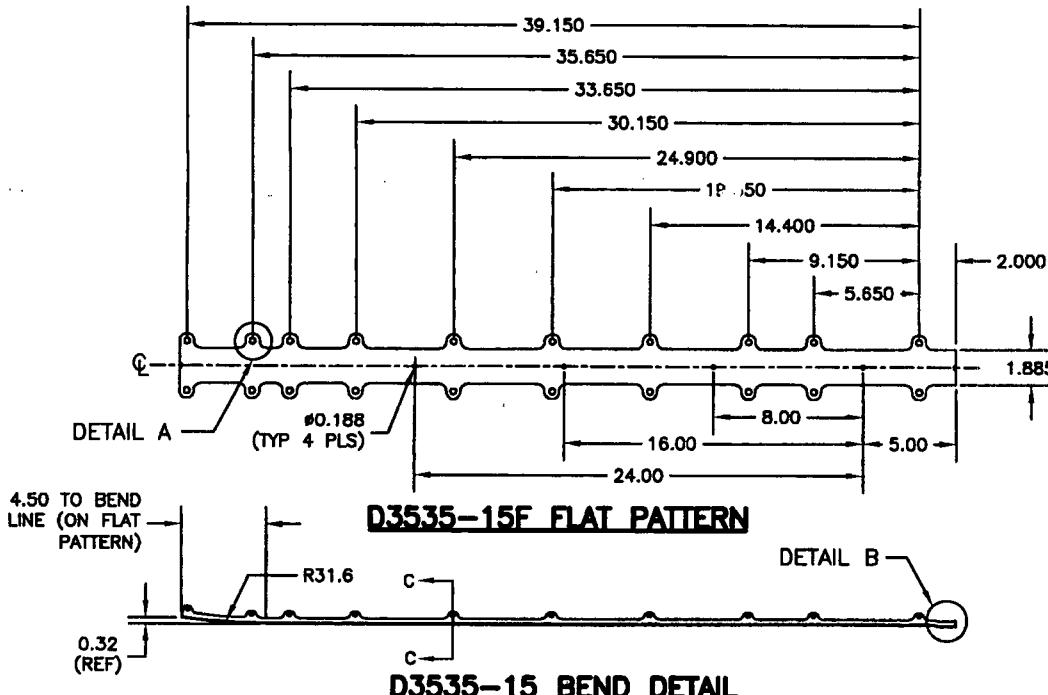
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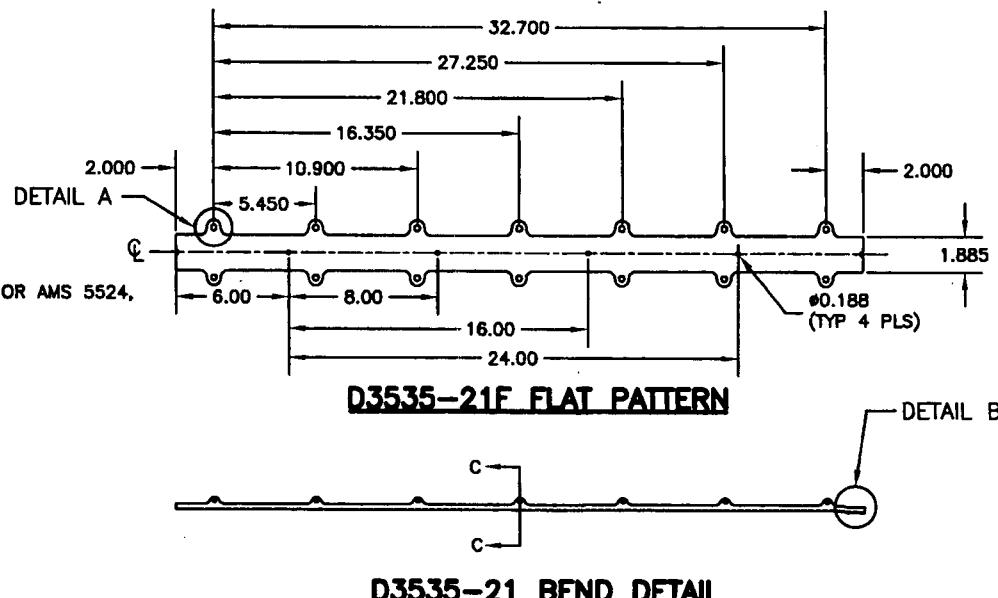
NOTE: Date & initial all entries

DART**RELEASED**
07.04.24 *ff*

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	PRT HADLOCK, WA
DATE	DRAWING NO.	REV. B
<i>ff</i>	<i>ff</i>	D3535
07.04.17	TITLE	WEARSHOE
	SCALE	1:10

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



W/O:		WORK ORDER CHANGES					
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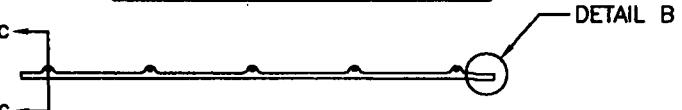
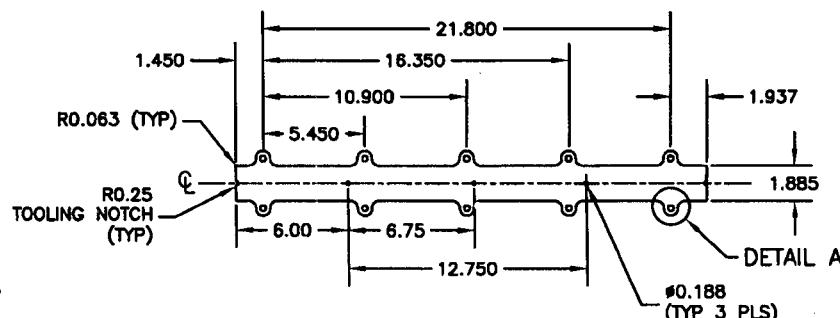
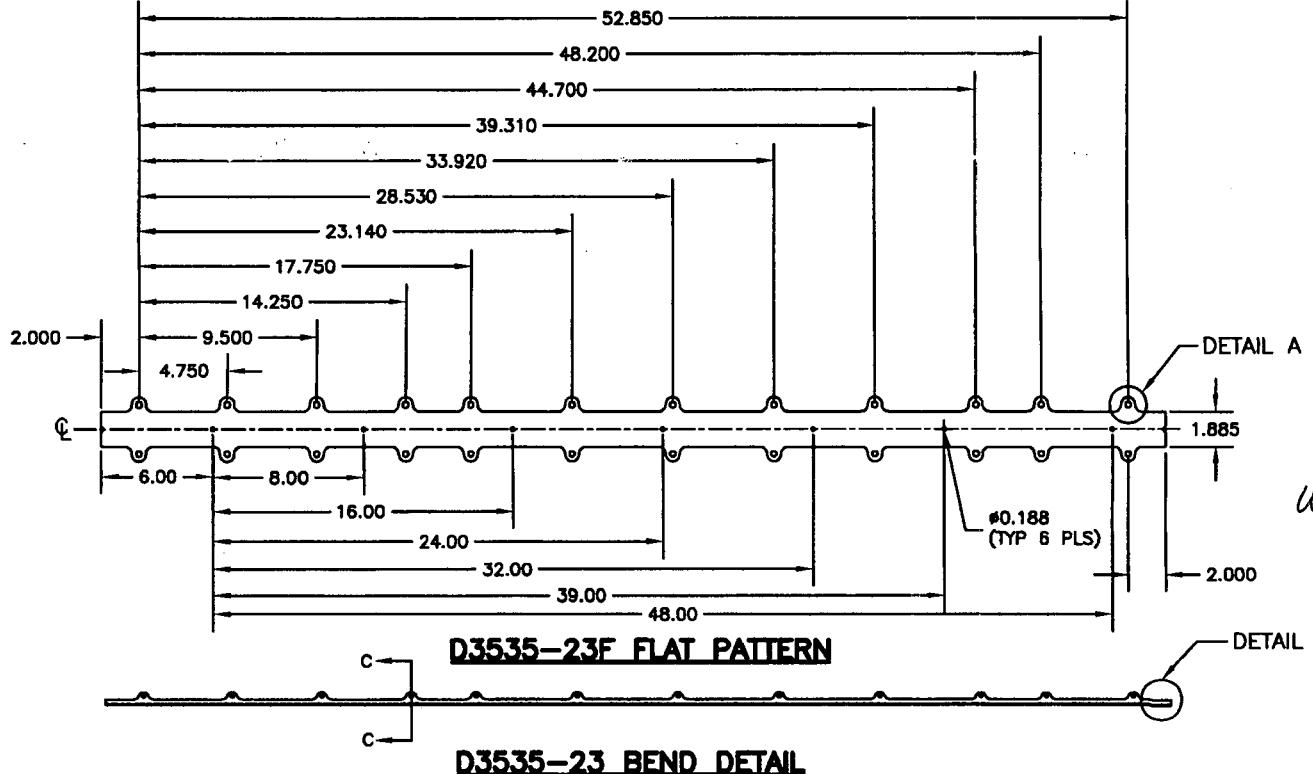
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	PW	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE		TITLE
07.04.17		WEARSHOE
		SCALE
		1:10
		REV. B
		SHEET 3 OF 7

RELEASED
07.04.24

W/0 43577



D3535-25 BEND DETAIL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

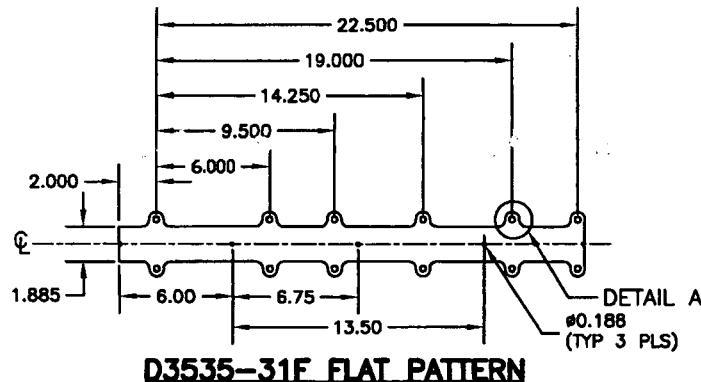
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DART

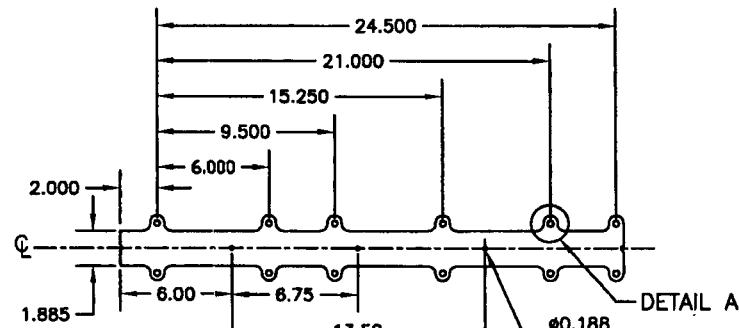
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07.04.24



D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

NOTES

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	PH	PORT HADLOCK, WA
<i>[initials]</i>	<i>[initials]</i>	DRAWING NO.
07.04.17		WEARSHOE
		REV. B
		SHEET 4 OF 7
		SCALE 1:10

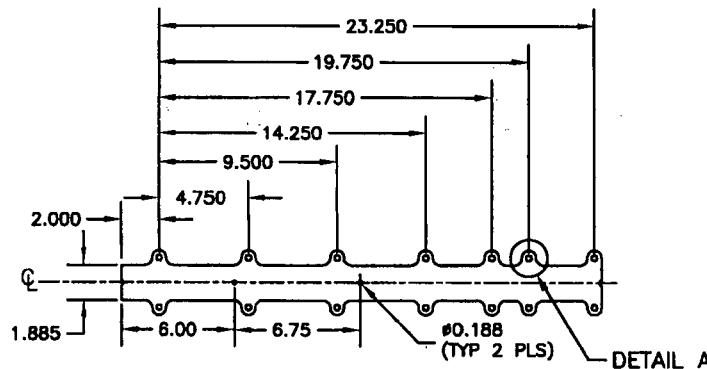
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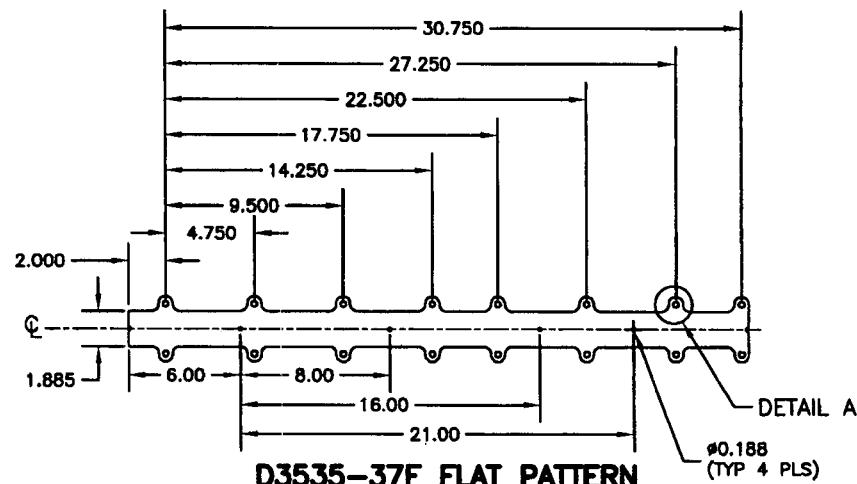
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DARTRELEASED
07.04.17**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL**

w/o 43577

**D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
07.04.17	PH	DRAWING NO.
		D3535
		TITLE
		WEARSHOE
		SCALE
		1:10

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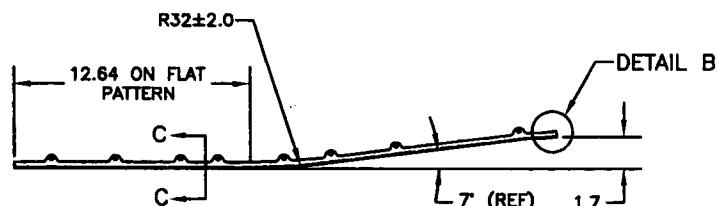
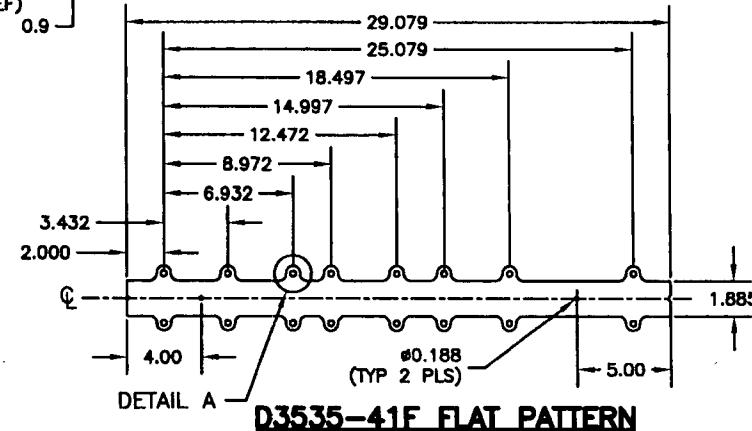
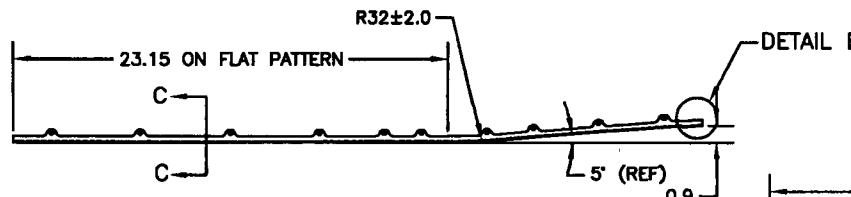
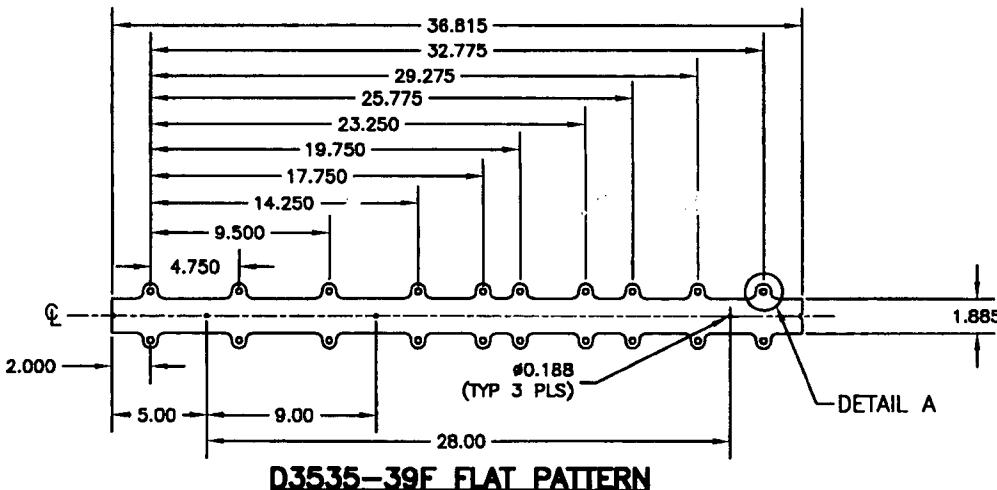
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DART

RELEASED
07.04.17

WU 43577

DESIGN CB	DRAWN BY PT	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED W	APPROVED W	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 6 OF 7 SCALE 1:10



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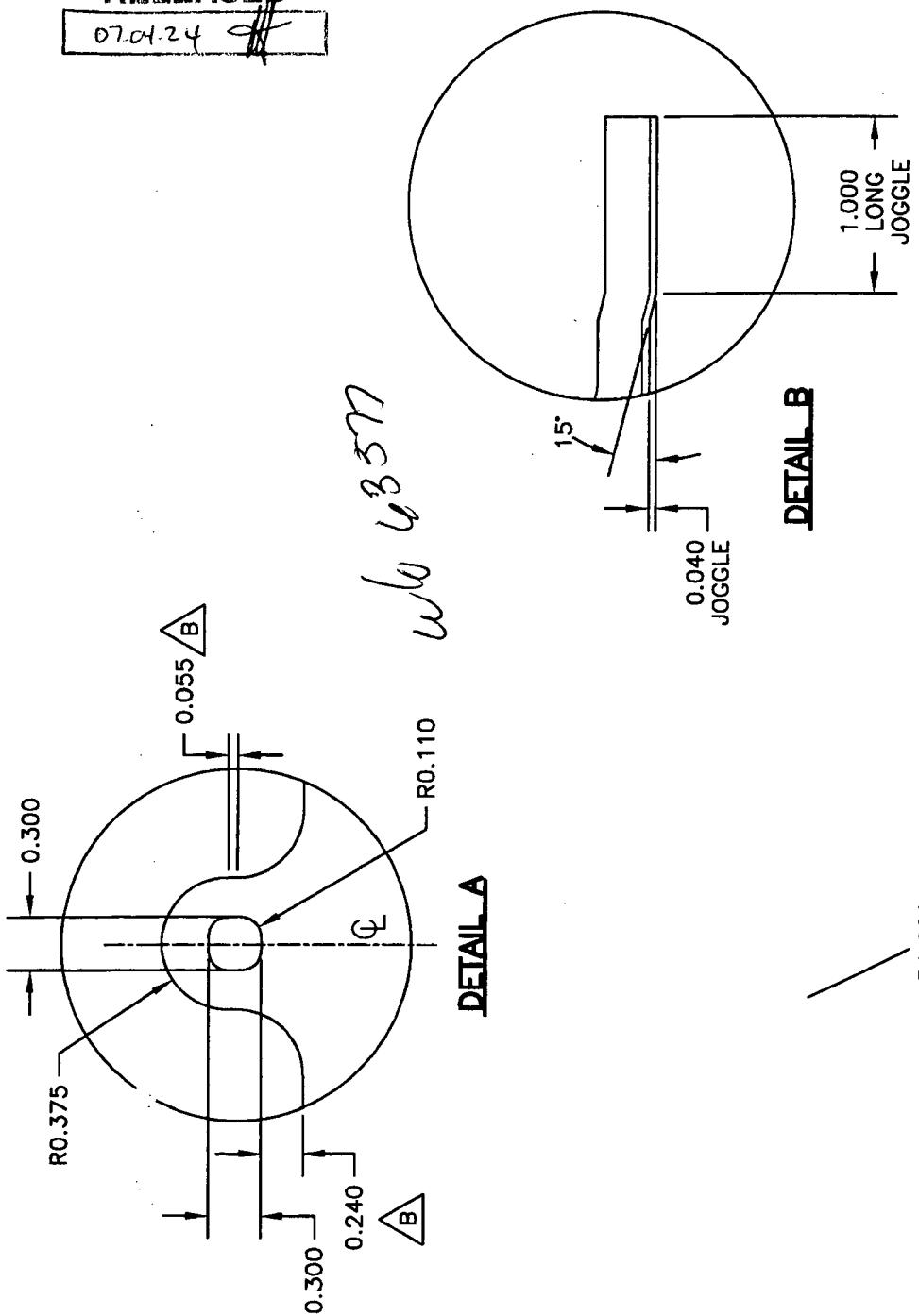
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DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

07.04.24 *[initials]*

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